

Date: Thursday, 5/3/2007 11:38:59 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SADDLE
 Job Number : 32203 Estimate Number : 12451
 P.O. Number : Part Number : D35001
 This Issue : 5/3/2007 S.O. No. : Drawing Number : D3500 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : 1/1 Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 31934 Material :
 Due Date : 6/10/2007 Qty: 30 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-06-15 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6102013 6061-T6 7.0x6.5x2.0



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: 1553681

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 30 Double check by: J.L

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QCB SECOND CHECK



Comment: SECOND CHECK

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 32203

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

re-alodine 07-11-12 (X30) 08/02/05

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

M105914 30X (9X) 07/14/12 08/02/05

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-02-05 (X9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 440

8/2/06 54 (9X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

Job Completion



2008/2/07 (9)

W

DART AEROSPACE LTD		Work Order: 32203
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.484	.484	.486	.485		
B	1.175	1.185		1.180	1.175	1.180	1.182		
C	3.145	3.155		3.148	3.148	3.150	3.151		
D	1.175	1.185		1.180	1.175	1.180	1.180		
E	0.365	0.385		.377	.378	.379	.378		
F	0.490	0.510		.500	.492	.494	.495		
H	R.470	R.530		.525	R.525	R.525	R.525		
I	R1.575	R1.595		R.1578	1.587	1.579	1.575		
J	0.240	0.260		.253	.254	.253	.252		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.625	3.623	3.625	3.625		
M	0.315	0.320		.316	.316	.320	.320		
N	0.256	0.262		.257	.257	.258	.257		
O	6.500	6.520		6.510	6.511	6.507	6.505		
P	5.990	6.010		6.008	6.008	6.000	6.005		
Q	2.820	2.830		2.825	2.823	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.124	1.125		
U	0.540	0.560		.553	.554	0.541	0.549		
V	0.793	0.803		.797	.797	.798	.796		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	0.50	0.50		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		R.1125	1.130	1.130	1.126		
AB	R.490	R.510		R.500	.500	R.500	R.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.260	.260	.260	.260		
AE	1.810	1.830		1.821	1.821	1.818	1.818		
AF	0.240	0.260		.251	.251	.252	.252		
AG	0.140	0.160		.150	.152	.152	.152		
AH	0.140	0.160		.155	.153	.153	.153		
AI	0.140	0.160		.155	.149	.153	.151		
Accept/Reject									

Measured by: SA	Audited by: JF
Date: 07.11.05	Date: 07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

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1900

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LIBRARY

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.181	1.180		
C	3.145	3.155		3.148	3.148	3.149	3.149		
D	1.175	1.185		1.180	1.180	1.181	1.180		
E	0.365	0.385		.379	.379	.379	.379		
F	0.490	0.510		.502	.502	.500	.497		
H	R.470	R.530		R.525	R.525	R.525	R.525		
I	R1.575	R1.595		1.580	1.591	1.575	1.579		
J	0.240	0.260		.253	.253	.258	.253		
K	0.490	0.510		.499	.500	.500	.501		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.319	.319	.319	.319		
N	0.256	0.262		.258	.258	.257	.258		
O	6.500	6.520		6.508	6.507	6.508	6.507		
P	5.990	6.010		5.994	5.994	5.998	5.994		
Q	2.820	2.830		2.825	2.825	2.825	2.827		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.252		
T	1.120	1.130		1.124	1.125	1.125	1.130		
U	0.540	0.560		.556	.547	.546	.547		
V	0.793	0.803		.797	.796	.797	.797		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		R1.128	R1.129	R1.126	R1.134		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.625	.625	.625	.626		
AD	0.240	0.260		.260	.260	.260	.254		
AE	1.810	1.830		1.815	1.815	1.815	1.817		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.152	.153	.152	.147		
AI	0.140	0.160		.147	.145	.153	.148		
Accept/Reject									

Measured by:	EC / MIA
Date:	07/11/07

Audited by:	J.F.
Date:	07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

1. The first part of the book is devoted to a general introduction to the subject of the book, and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

2. The second part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

3. The third part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

4. The fourth part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

5. The fifth part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

6. The sixth part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

7. The seventh part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

8. The eighth part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

9. The ninth part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

10. The tenth part of the book is devoted to a detailed discussion of the various methods of determining the value of the function $f(x)$ at a given point x , and to a discussion of the various methods of determining the value of the function $f(x)$ at a given point x .

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.483	0.490		.485	.486	.486	.485		
B	1.175	1.185		1.179	1.179	1.180	1.179		
C	3.145	3.155		3.147	3.150	3.150	3.147		
D	1.175	1.185		1.179	1.180	1.180	1.179		
E	0.365	0.385		.377	.379	.379	.378		
F	0.490	0.510		.497	.501	.500	.495		
H	R.470	R.530		.525	.525	.525	.523		
I	R1.575	R1.595		1.579	1.579	1.578	1.580		
J	0.240	0.260		.252	.251	.253	.251		
K	0.490	0.510		.500	.503	.503	.499		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.319	.320	.320	.319		
N	0.256	0.262		.257	.258	.257	.257		
O	6.500	6.520		6.507	6.500	6.501	6.507		
P	5.990	6.010		6.002	6.004	6.001	6.001		
Q	2.820	2.830		2.824	2.826	2.826	2.824		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.249	2.249	2.2500	2.253		
T	1.120	1.130		1.125	1.128	1.126	1.127		
U	0.540	0.560		.544	.545	.549	.546		
V	0.793	0.803		.797	.800	.802	.799		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		1.132	1.133	1.132	1.133		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.630	.628	.630	.629		
AD	0.240	0.260		.253	.253	.254	.254		
AE	1.810	1.830		1.812	1.812	1.812	1.812		
AF	0.240	0.260		.250	.250	.249	.250		
AG	0.140	0.160		.151	.150	.150	.150		
AH	0.140	0.160		.150	.147	.140	.150		
AI	0.140	0.160		.148	.148	.147	.148		
Accept/Reject									

Measured by:	BC / HA
Date:	02-11-07

Audited by:	JF
Date:	07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

1870-1871

1872-1873

1874-1875

1876-1877

1878-1879

1880-1881

1882-1883

1884-1885

1886-1887

1888-1889

1890-1891

1892-1893

1894-1895

1896-1897

1898-1899

1900-1901

1902-1903

1904-1905

1906-1907

1908-1909

1910-1911

1912-1913

1914-1915

1916-1917

1918-1919

1920-1921

1922-1923

1924-1925

1926-1927

1928-1929

1930-1931

1932-1933

1934-1935

1936-1937

1938-1939

1940-1941

1942-1943

1944-1945

1946-1947

1948-1949

1950-1951

1952-1953

1954-1955

1956-1957

1958-1959

1960-1961

1962-1963

DART AEROSPACE LTD		Work Order: 32203
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 13	2 14	3	4		
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.149	3.149	3.149	3.149		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.378	.378	.378	.378		
F	0.490	0.510		.499	.499	.500	.4995		
H	R.470	R.530		R.525	R.525	R.525	R.525		
I	R1.575	R1.595		1.570	1.580	1.580	1.579		
J	0.240	0.260		.255	.251	.252	.253		
K	0.490	0.510		.499	.499	.502	.503		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.319		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.500	6.509	6.508		
P	5.990	6.010		6.001	6.001	5.999	6.003		
Q	2.820	2.830		2.829	2.825	2.826	2.826		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.253	2.252	2.253	2.253		
T	1.120	1.130		1.125	1.127	1.121	1.130		
U	0.540	0.560		.546	.546	.547	.553		
V	0.793	0.803		.809	.801	.800	.799		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		1.134	1.134	1.134	1.133		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.255	.254	.254	.255		
AE	1.810	1.830		1.817	1.817	1.817	1.8175		
AF	0.240	0.260		.250	.247	.250	.248		
AG	0.140	0.160		.149	.150	.150	.149		
AH	0.140	0.160		.140	.146	.147	.150		
AI	0.140	0.160		.147	.146	.148	.149		
Accept/Reject									

Measured by: <i>BEI</i>
Date: <i>MA</i>

Audited by: <i>JE</i>
Date: <i>07/11/09</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 32203
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.485	.485	.486		
B	1.175	1.185		1.181	1.178	1.179	1.179		
C	3.145	3.155		3.157	3.158	3.149	3.149		
D	1.175	1.185		1.181	1.178	1.179	1.179		
E	0.365	0.385		.378	.377	.378	.379		
F	0.490	0.510		.497	.498	.499	.499		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.583	1.5835	1.587	1.586		
J	0.240	0.260		.252	.252	.250	.250		
K	0.490	0.510		.502	.500	.495	.493		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.257	.257	.258		
O	6.500	6.520		6.507	6.508	6.507	6.510		
P	5.990	6.010		6.008	6.008	6.005	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.257	2.257	2.255	2.250		
T	1.120	1.130		1.128	1.128	1.127	1.124		
U	0.540	0.560		.553	.551	.551	.549		
V	0.793	0.803		.799	.799	.799	.799		
W	R.240	R.260		R.250	.250	.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		1.132	1.133	1.136	1.136		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.633	.630	.630	.630		
AD	0.240	0.260		.254	.254	.255	.254		
AE	1.810	1.830		1.818	1.818	1.815	1.815		
AF	0.240	0.260		.247	.247	.250	.252		
AG	0.140	0.160		.149	.149	.152	.152		
AH	0.140	0.160		.151	.150	.150	.149		
AI	0.140	0.160		.146	.150	.150	.149		
Accept/Reject									

Measured by:	SA
Date:	07.11.08

Audited by:	JF
Date:	27/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.55	.486	.486	.486		
B	1.175	1.185		1.179	1.179	1.175	1.181		
C	3.145	3.155		3.141	3.149	3.140	3.149		
D	1.175	1.185		1.175	1.175	1.179	1.181		
E	0.365	0.385		.378	.378	.378	.377		
F	0.490	0.510		.497	.502	.501	.497		
H	R.470	R.530		.525	.525	.523	.525		
I	R1.575	R1.595		1.584	1.586	1.586	1.581		
J	0.240	0.260		.249	.248	.248	.249		
K	0.490	0.510		.502	.502	.502	.501		
L	3.590	3.650		3.625	3.625	3.623	3.623		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.509	6.505	6.510		
P	5.990	6.010		6.003	5.995	5.995	6.007		
Q	2.820	2.830		2.825	2.825	2.823	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.123	1.126	1.127	1.126		
U	0.540	0.560		.551	.545	.545	.550		
V	0.793	0.803		.790	.795	.795	.797		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		1.134	1.135	1.126	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.254	.254	.254	.253		
AE	1.810	1.830		1.814	1.814	1.814	1.814		
AF	0.240	0.260		.251	.250	.250	.250		
AG	0.140	0.160		.151	.151	.150	.152		
AH	0.140	0.160		.148	.148	.149	.148		
AI	0.140	0.160		.150	.151	.150	.150		
Accept/Reject									

Measured by:	SA
Date:	02/11/08

Audited by:	J.F
Date:	27/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

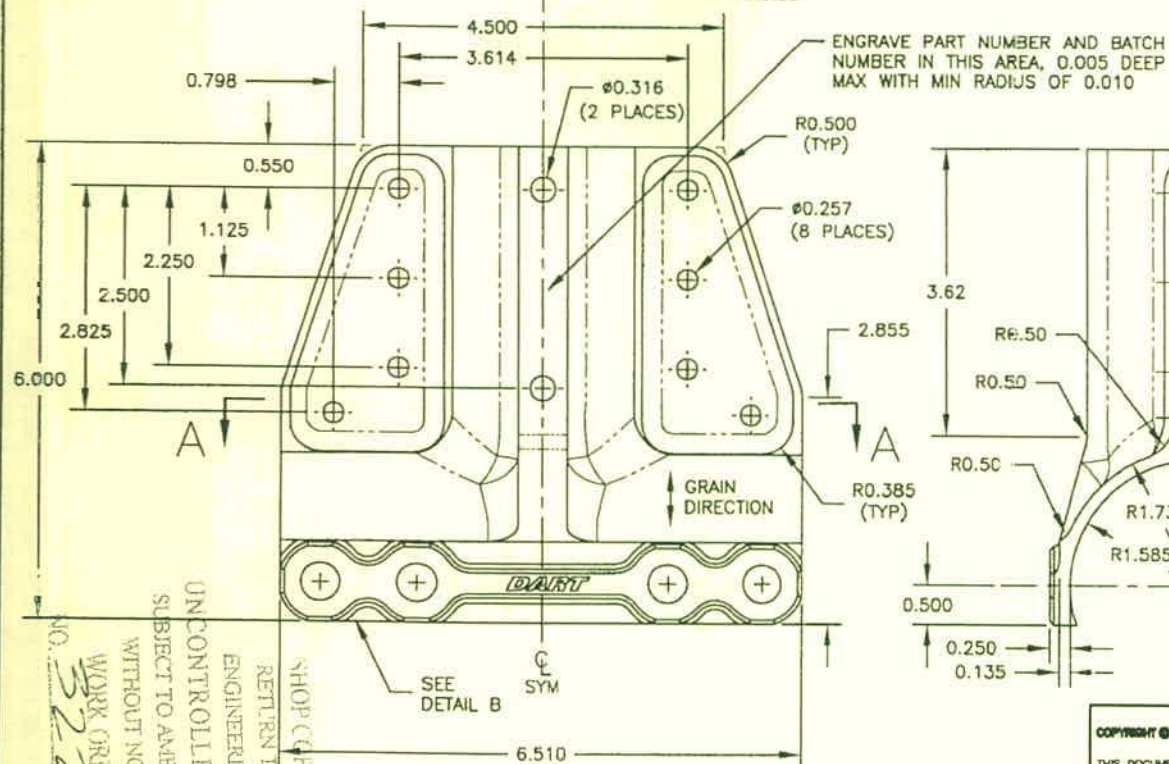
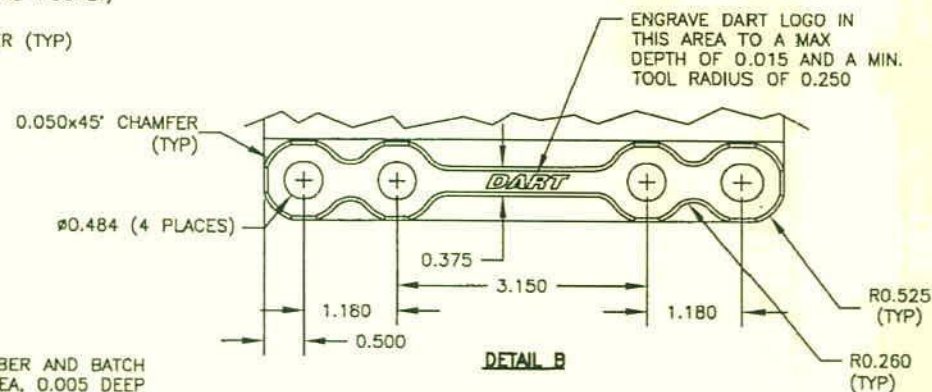
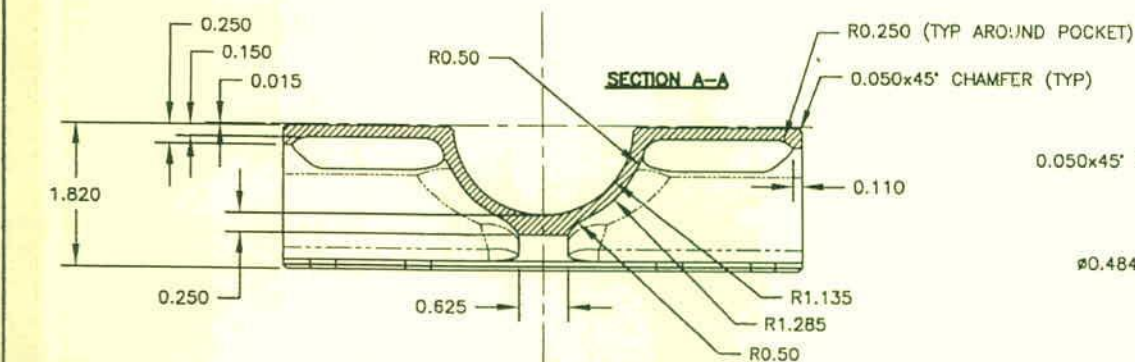
DART AEROSPACE LTD		Work Order: 32203
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486				
B	1.175	1.185		1.175	1.181				
C	3.145	3.155		3.145	3.157				
D	1.175	1.185		1.175	1.180				
E	0.365	0.385		.377	.370				
F	0.490	0.510		.501	.501				
H	R.470	R.530		.525	.528				
I	R1.575	R1.595		1.581	1.580				
J	0.240	0.260		.251	.257				
K	0.490	0.510		.495	.501				
L	3.590	3.650		3.625	3.605				
M	0.315	0.320		.320	.320				
N	0.256	0.262		.258	.258				
O	6.500	6.520		6.570	6.570				
P	5.990	6.010		5.998	6.001				
Q	2.820	2.830		2.825	2.825				
R	2.495	2.505		2.500	2.500				
S	2.245	2.255		2.250	2.248				
T	1.120	1.130		1.125	1.125				
U	0.540	0.560		.545	.545				
V	0.793	0.803		.799	.800				
W	R.240	R.260		.250	.250				
X	0.040	0.060		.050	.050				
Y	0.100	0.120		.120	.120				
AA	R1.125	R1.145		1.136	1.15				
AB	R.490	R.510		.500	.50				
AC	0.615	0.635		.630	.630				
AD	0.240	0.260		.255	.255				
AE	1.810	1.830		1.815	1.817				
AF	0.240	0.260		.250	.250				
AG	0.140	0.160		.151	.151				
AH	0.140	0.160		.145	.150				
AI	0.140	0.160		.151	.149				
Accept/Reject									

Measured by:	SD
Date:	07.11.08

Audited by:	JF
Date:	07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	JA



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	90	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	06.06.30	DRAWING NO. D3500
		TITLE SADDLE
		REV. C
		SHEET 1 OF 1
		SCALE 2:3

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HAMPSHIRE, ENGLAND, CANADA

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